

Date: Thursday, 05/02/2009 3:46:35 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PROP ASSEMBLY
Job Number : 45557	
Estimate Number : 11558	
P.O. Number :	Part Number : D3085041
This Issue : 05/02/2009 S.O. No. :	Drawing Number : D3085 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 38320	Material :
Written By :	Due Date : 28/02/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUL 09 02 06</u>	
Comment : Est. B02.03.05 Added dwg Rev.A1 NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D30153	Locknut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lock Nut

Pick:

Qty	Part Number	Description	Batch
1	D3015-3	Locknut	B415394

9/5/13

SQ

2.0	D30811	Hinge
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge

Pick:

Qty	Part Number	Description	Batch
1	D3081-1	Prop Hinge	B44081

9/5/13

9/5/13

3.0	D30821	Clip
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clip

Pick:

Qty	Part Number	Description	Batch
1	D3082-1	Clip	B44025

9/5/13

SQ

4.0	D30841	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Pick:

Qty	Part Number	Description	Batch
1	D3084-1	Prop arm	B44364

2

9/5/13

SQ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:46:36 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ASSEMBLY

Job Number: 45557

Part Number: D3085041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

1 AN4-5A Bolt M109061

9/5/13

SL

6.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer M111279

9/5/13

SL

7.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

3 AN960JD10L Washer M105793

9/5/13

SL

8.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer M110363

9/5/13

SL

9.0

AN960JD516L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD516L Washer M14477

9/5/13

(42)

SL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: PROP ASSEMBLY

Job Number: 45557

Part Number: D3085041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch
3 MS21042L3 Nut(or MS21042-3) M108701

9/5/13

sl

11.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch
1 MS21042L4 Nut(or MS21042-4) M110450

sl

12.0

MS27039113

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Pick:

Qty Part Number Description Batch
3 MS27039-1-13 Screw M105211

sl

13.0

SL69BS

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Ball Stud

Pick:

Qty Part Number Description Batch
1 SL69-BS Ball Stud M109239

9/5/13

sl

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D3085

2/5/09/05/5 (4)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 02/05/19 (72)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: PROP ASSEMBLY

Job Number: 45557

Part Number: D3085041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



4X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 271

9/5/9

SC

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/2009

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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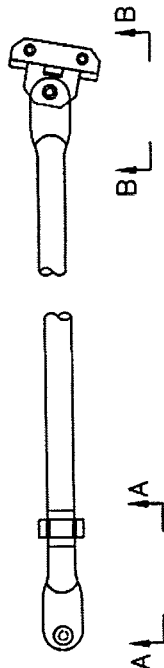
NOTE: Date & initial all entries

DART

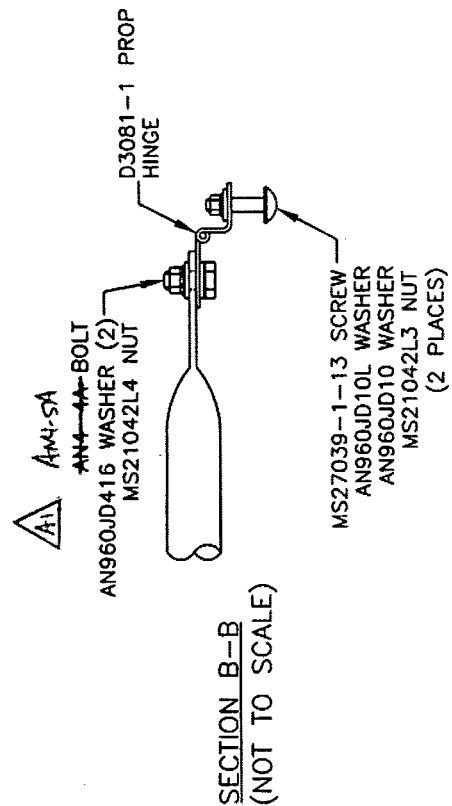
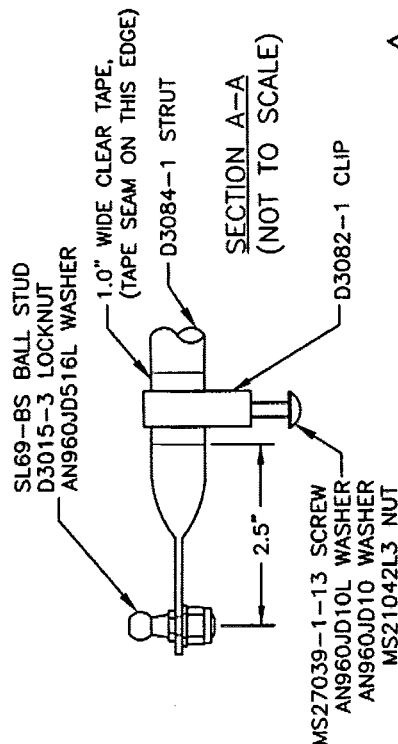


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3085	REV. A SHEET 1 OF 1
DATE	02.01.23	TITLE	PROP ARM ASSEMBLY	SCALE	1:5
A	02.01.23	NEW ISSUE			
A1	# CP 02.02.25	AN4-SA WAS AN4-4A			

RELEASED
02-01-25



D3085-041 PROP ARM ASSEMBLY



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15555

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